

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013180**Date Inspected:** 08-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 7BE+7CE weld splice and temporary attachments locations. The weld designations reviewed are as follows:

7BE+7CE

1. OBE7-006, 007, 008, 009 and 010

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 0008 located at BP059-001 counter weight of segment. Welder is identified as Mr. Fang Xianyou (037748). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-B-P-U2-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

7BW+7CW

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various t stiffeners located on the side plates counter weight side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

Shield Metal Arc Welding (SMAW) VT repair welding was performed on various t stiffeners located on the side plate cross beam side of segment. Welder is identified as Mr. Chen Hongjun (045221). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

7AW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 018 located at SEG033B counter weight of segment. Welder is identified as Mr. Xu Zichuan (205098). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2213-U4b-FCM-1.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions on ZPMC Ship. Locations and description of work are as followed:

7DE

1. Ut reject excavation in progress at the deck plate to edge plate weld joint located at the bike path side of segment. Y locations are as followed: 1010~1060mm, 1840~1890mm, 1960mm, 2525mm, 3190~3250mm, 3580mm, 3870~3925mm, 4380~4470mm, 5250mm, 5405~5690mm, 6840~6880mm, 7300mm, 9300~9320mm, 11700~11825mm, 13010 and 13280~13515mm.

7AE

1. Grit blasting of the deck plate and edge plate (external) of segment.

7BW+7CW

This QA Inspector observed ZPMC welder Chen Hongjun (067609) welding in the 3G position on weld joint OBW7B-007, located on the counter weight side of segment. QA Inspector asked for welder's qualification card to verify the position qualified. QA Inspector noted welder was qualified in the 4G position and not the 3G position. (Welding out of position) This QA Inspector issued an incident report for noted issue.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
